

Date: Thursday, 4/27/2006 12:46:36 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 A/B HIGH GEAR WEB
 Job Number : 26865
 Estimate Number : 10455
 P.O. Number : N/A Part Number : D26543
 This Issue : 4/27/2006 S.O. No. : N/A Drawing Number : D2654 REV E1
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : E1
 Previous Run : 25979 Material : N/A
 Due Date : 5/10/2006 Qty: 10 Um: Each
 Written By : See Comment Below
 Checked & Approved By :
 Comment : Est Rev:D 99.02.04 Fixed typo, Changed procedureDM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D26005108 Extrusion 'I Beam' thin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------------------|
| 1 | D2600-5 | Web | B24410 IT 06-04-27 ✓ |

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2654 IT 06-04-27
 2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654 IT 06-04-27
 3-Using the uni-bit, open holes to finish size as per Dwg D2654 IT 06-04-27
 4-Deburr holes and ends IT 06-04-28

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 06-4-28 ✓

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 IT 06-04-28 ✓

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 24/03/03
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|----------------------|---------------------------------|----------------|--|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | | |
| | | | | | | | | | |
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NOTE: Date & initial all entries

Date: Thursday, 4/27/2006 12:46:36 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR WEB

Job Number: 26865

Part Number: D26543

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 05-5-2

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

DP 06-5-2

10

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

QD 06/05/03

Job Completion



06-05-03

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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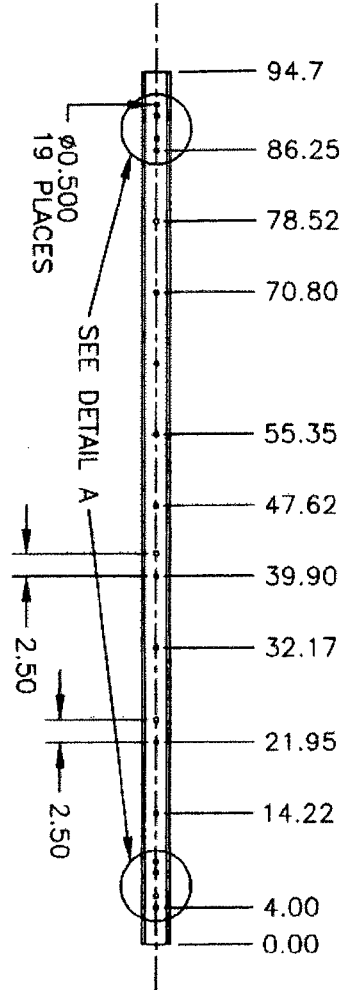
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|----------------------|---------------------------------|----------------|--|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | | |
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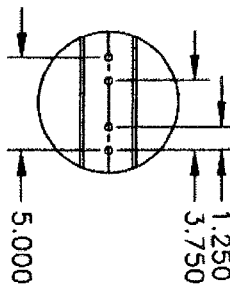
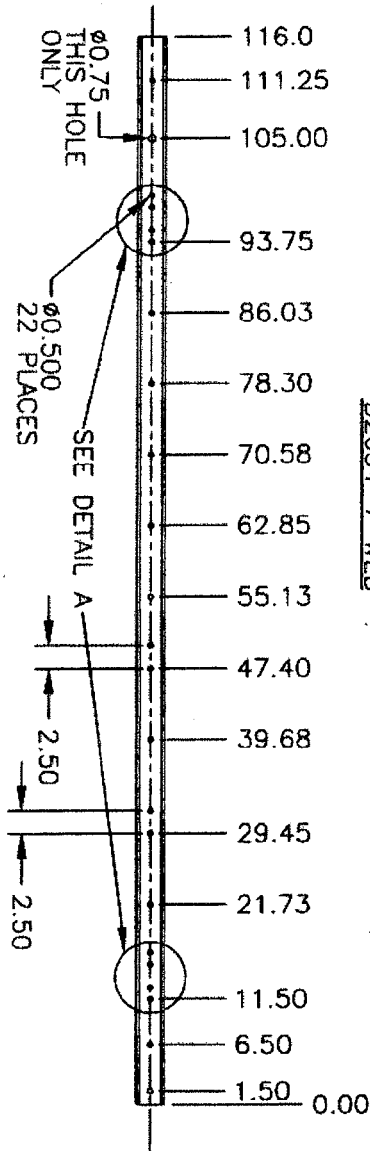
NOTE: Date & initial all entries

D2654-5 WEB



DETAIL A
 SCALE 1:10

D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
 FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1
 TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED

REFERENCE ONLY

RELEASED
 04.05.26

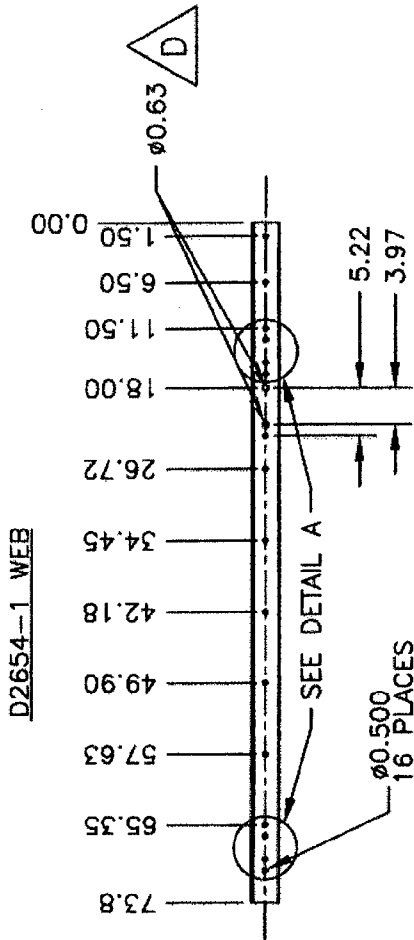


| | | | |
|--|--------------|-------|----------|
| DESIGN | CHECKED | DATE | 04.05.26 |
| DRAWN BY | APPROVED | TITLE | WEB |
| D2654 | D2654 | SCALE | 1:20 |
| REV. E | SHEET 2 OF 2 | | |
| DART Aerospace USA, Inc. PORT HADLOCK, WA | | | |

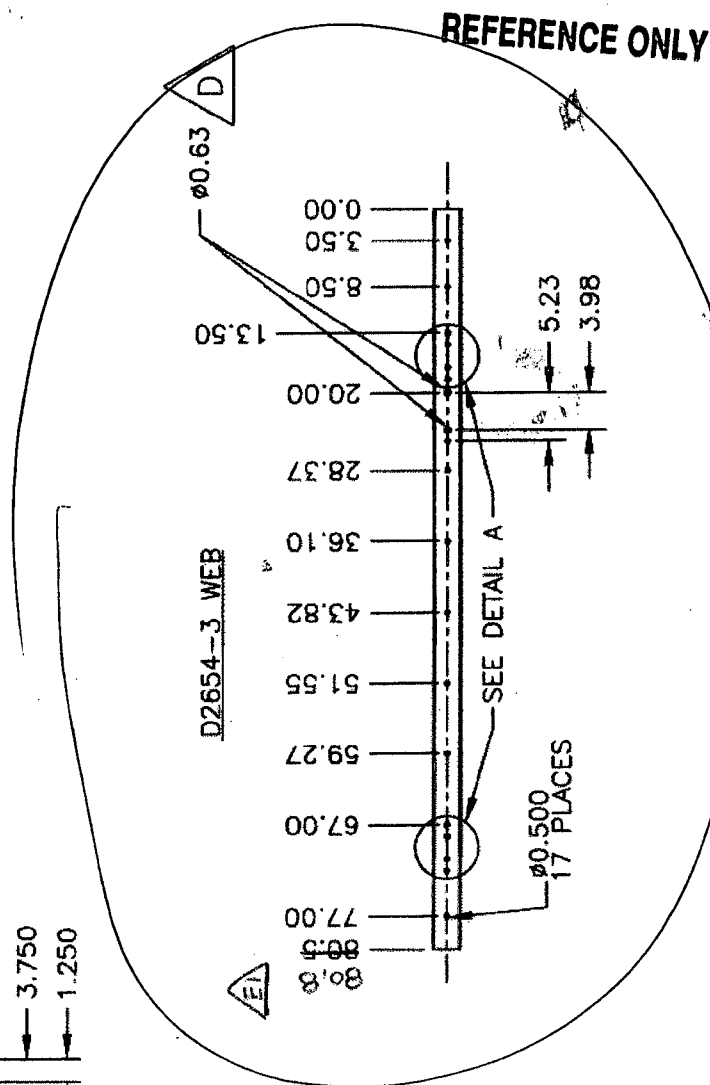
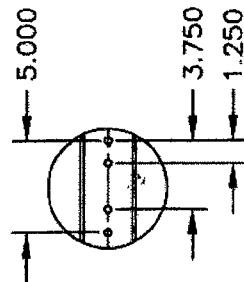


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|------------------|------------|-------------|------------------------------------|--|----------------------------|
| DESIGN CP | | DRAWN BY CP | | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED # | APPROVED # | | DRAWING NO. D2654 | | REV. E SHEET 1 OF 2 |
| DATE 04.05.26 | | | TITLE WEB SCALE 1:20 | | |
| A | 97.03.25 | | NEW ISSUE | | |
| B | 97.06.26 | | ALTER HOLE PATRN., 0.500 WAS 0.438 | | |
| C | 97.10.29 | | CHANGED HOLE PATTERN | | |
| D | 98.01.15 | | GHW HOLES CHANGED TO Ø0.63 | | |
| E | 04.05.26 | | CHANGE LENGTHS, REFORMAT | | |
| E1 | CP # | 04.08.04 | PER TOOLING; 80.8 WAS 80.5 | | |

RELEASED
04.06.22



DETAIL A
SCALE 1:10



MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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